

Date: Thursday, 9/20/2007 3:29:12 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SADDLE FITTING, AFT (OUTBOARD/INBOARD)			
Job Number	34750	Part Number	D2573			
Estimate Number	10533	Drawing Number	D2573 REV E			
P.O. Number	N/A	Project Number	N/A			
This Issue	9/20/2007	S.O. No.	N/A			
Prsht Rev.	NC	Type	MACHINED PARTS			
First Issue	N/A	Material	N/A			
Previous Run	34369	Due Date	10/1/2007			
Written By						Qty: 12 Um: Each
Checked & Approved By	<u>JLM</u> 07.09.02					
Comment	Est: 1 As Per RevE 06-01-27 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: <u>B31389</u> <u>JLM</u> 07.01.02 12</p>			
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
<p>Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>34750</u> Double check by: <u>RG</u></p> <p>1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.</p> <p style="text-align: right;"><u>J.L/EE</u> 07.10.04 (2)</p>			
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
<p>Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574 <u>J.L/EE</u> 07.10.04 (2)</p>			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>J.L/EE</u> 07.10.04 (2)</p>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/01/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/20/2007 3:29:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 34750

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

7/10/15 (12)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(12x)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m-f 07/10/15

7.0 POWDER COATING POWDER COATING



1105068

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

41 07-10-16

(12)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

7/10/16 (12)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/10/16 (12)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/10/17 (12)

Job Completion



7/10/17

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	34750
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	.440	.442	.440		
B	1.745	1.755		1.750	1.750	1.751	1.751		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.751		
E	7.990	8.010		8.000	8.000	8.003	8.002		
F	0.490	0.510		0.505	.505	.505	.505		
G	0.257	0.262	DT8683	0.258	0.259	0.259	.259		
H	0.375	0.380	DT8684	0.377	0.377	0.376	.377		
I	0.490	0.510		0.501	0.501	0.500	.500		
J	1.174	1.184		1.178	1.178	1.178	1.181		
K	0.558	0.578		0.567	0.567	0.568	.568		
L	1.174	1.184		1.178	1.178	1.178	1.181		
M	1.365	1.375		1.368	1.368	1.368	1.368		
N	2.495	2.505		2.499	2.500	2.499	2.500		
O	4.119	4.129		4.121	4.121	4.122	4.122		
P	0.115	0.135		0.124	0.124	0.123	.125		
Q	0.115	0.135		0.135	0.135	0.135	.135		
R	0.240	0.260		0.253	0.253	0.253	.253		
S	0.115	0.135		0.122	0.120	0.123	.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.229	3.230	3.230		
V	0.230	0.250		0.244	0.242	0.242	242		
W	0.115	0.135		0.127	0.123	0.128	.128		
X	0.308	0.313		0.311	.311	.311	.311		
Y	0.760	0.765		0.766	.760	.764	.764		
Z	0.352	0.372		0.358	.365	.365	.365		
AA	0.470	0.530		0.500	0.500	0.500	0.506		
AB	0.615	0.635		0.633	.626	.630	.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.255	0.252	0.252	.252		
AE	1.500	1.520		1.510	1.511	1.510	1.513		
AF	0.115	0.135		0.129	0.126	0.125	.125		
AG	0.240	0.280		0.260	0.260	0.260	.260		
AH	0.240	0.260		0.253	0.252	0.252	.252		
AI	2.000	2.020		2.000	2.001	2.001	2.001		
AJ	0.023	0.043		0.033	.033	.033	.033		
Accept/Reject									

Measured by: *Ed / S.L.*
Date: 02.10.11

Audited by: *cmh*
Date: 07/10/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>Ed</i> <i>JLM</i>	



DART AEROSPACE LTD				Work Order:	34750
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5"	6"	7"	8"		
A	0.438	0.443	DT8682	.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.002	8.005		
F	0.490	0.510		.508	.506	.506	.506		
G	0.257	0.262	DT8683	.257	.259	.259	.259		
H	0.375	0.380	DT8684	.377	.377	.377	.377		
I	0.490	0.510		.502	.508	.500	.500		
J	1.174	1.184		1.178	1.180	1.180	1.181		
K	0.558	0.578		.571	.574	.572	.572		
L	1.174	1.184		1.178	1.180	1.180	1.181		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.501	2.501	2.501		
O	4.119	4.129		4.120	4.124	4.124	4.124		
P	0.115	0.135		.125	.126	.126	.126		
Q	0.115	0.135		.125	.125	.127	.127		
R	0.240	0.260		.250	.252	.257	.257		
S	0.115	0.135		.125	.125	.120	.120		
T	0.178	0.198		.184	.188	.188	.188		
U	3.210	3.250		3.234	3.238	3.234	3.231		
V	0.230	0.250		.240	.240	.244	.244		
W	0.115	0.135		.120	.127	.127	.127		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.764	.764	.764	.764		
Z	0.352	0.372		.365	.365	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.511	1.511	1.511	1.513"		
AF	0.115	0.135		.125	.130	.130	.130		
AG	0.240	0.280		.250	.250	.276	.276		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.010	2.010	2.009	2.002"		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

Measured by: Q.F
Date: 07/10/04

Audited by: Q.M.L
Date: 07/10/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <u>Q.F</u>	<u>JLM</u>

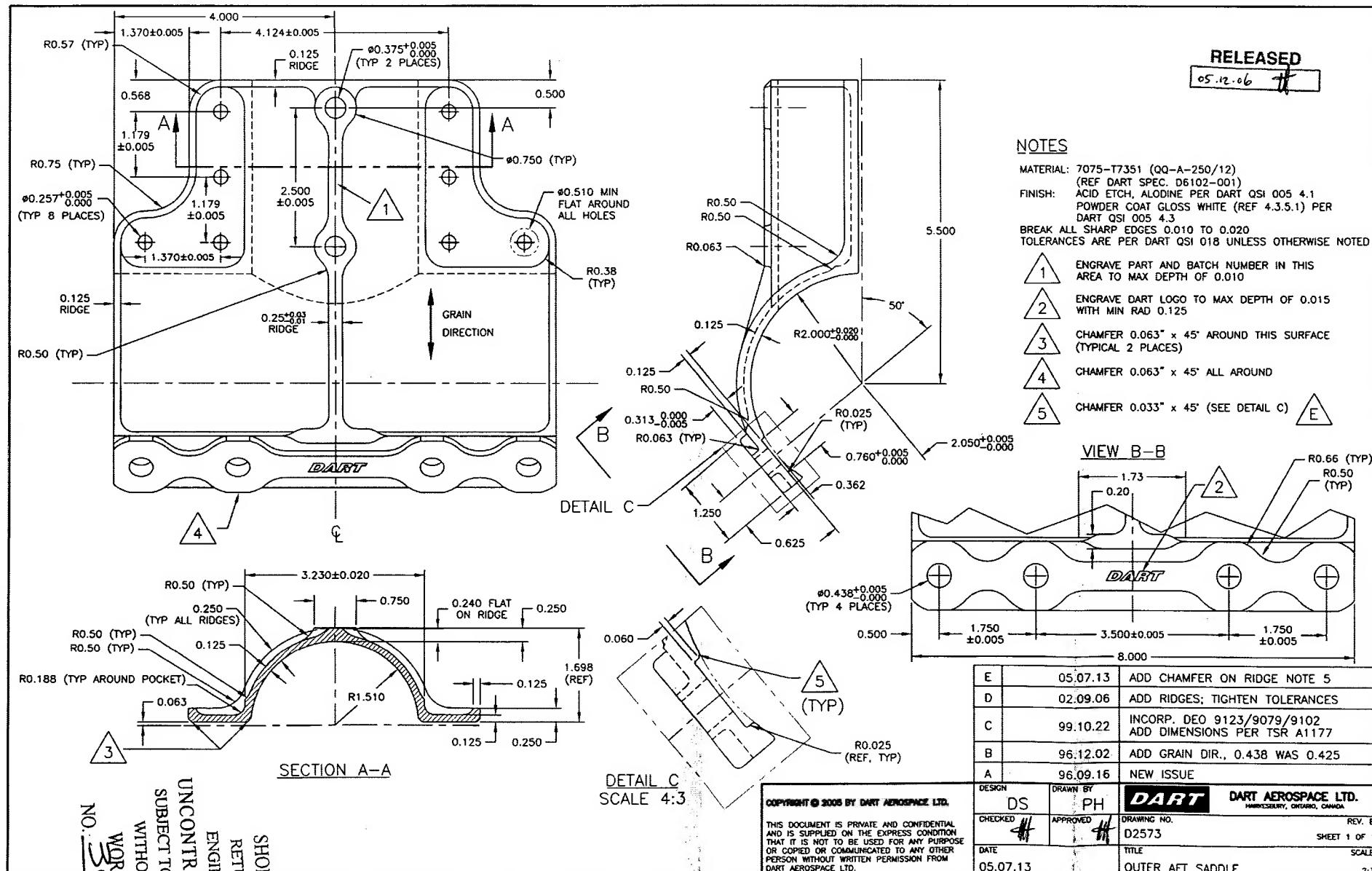
DART AEROSPACE LTD				Work Order: 34750
Description: Saddle, Aft Outboard				Part Number: D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9	2	3	4	By	Date
A	0.438	0.443	DT8682	.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.005	8.005	8.005	8.005		
F	0.490	0.510		.506	.506	.506	.506		
G	0.257	0.262	DT8683	.257	.258	.258	.258		
H	0.375	0.380	DT8684	.377	.376	.376	.376		
I	0.490	0.510		.505	.505	.505	.505		
J	1.174	1.184		1.177	1.179	1.179	1.179		
K	0.558	0.578		.573	.573	.573	.576		
L	1.174	1.184		1.177	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.501	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.124	.124	.124		
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.252	.254	.254	.254		
S	0.115	0.135		.126	.126	.126	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.243	.243	.243	.245		
W	0.115	0.135		.128	.128	.128	.128		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.764	.764	.764	.764		
Z	0.352	0.372		.366	.366	.366	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.255	.255	.255		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.250	.260	.260	.260		
AH	0.240	0.260		.252	.252	.252	.252		
AI	2.000	2.020		2.003	2.003	2.003	2.003		
AJ	0.023	0.043		.040	.040	.040	.040		
Accept/Reject									

Measured by:	<i>JK</i>	Audited by:	<i>JK</i>
Date:	07.10.14	Date:	07.10.15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JK</i>	<i>JLM</i>



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DESIGN	DRAWN BY	DART		DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
DS	PH			REV. E
CHECKED	APPROVED			DRAWING NO. D2573
				SHEET 1 OF 1
DATE				TITLE
05.07.13				OUTER AFT SADDLE
				SCALE 2:3

